

ASAP

Date: Thursday, 7/19/2007 2:25:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD			
Job Number	: 33660 - 1		<i>Split -</i>				
Estimate Number	: 12712		Part Number	: D35371			
P.O. Number	: N/A		Drawing Number	: D3537 REV C			
This Issue	: 7/19/2007	S.O. No.	: N/A		Project Number	: N/A	
Prsht Rev.	: NC		Drawing Revision	: C			
First Issue	: N/A		Material	: N/A			
Previous Run	: 33284		Due Date	: 7/31/2007			
Written By			Qty:	100			
Checked & Approved By			Um:	Each			
Comment	: Est Rev A		New Issue 07-02-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304S16GA	304/316 .063 Sheet		
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 6.3000 sf(s) M304S16GA .063" 304 SS SHEET Batch: M105061		SAD 07/07/20
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C		SAD 07/07/20 108
		2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		SAD 07/07/20 108
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		SP 07/07/20 108 counter
5.0	BRAKE NC	NC BRAKE		
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1		FF. 07-07-31 108

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng & Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/07/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33660

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat M105258

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

bd 07/08/02

(50)

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



M104846

(50)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/08/03

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/08/07 (50)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

FL

07/08/07

(50)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

R Dart/08/08

Job Completion



JULY 07 2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33660
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

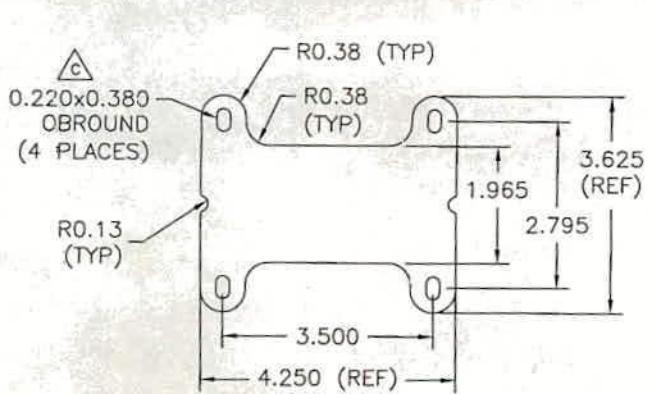
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

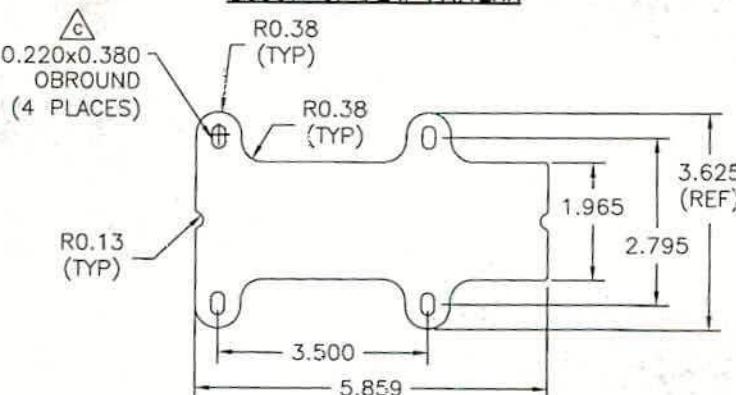
Measured by:	SAD	Audited by:	Ss	Prototype Approval:	N/A
Date:	07/07/20	Date:	07/07/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>

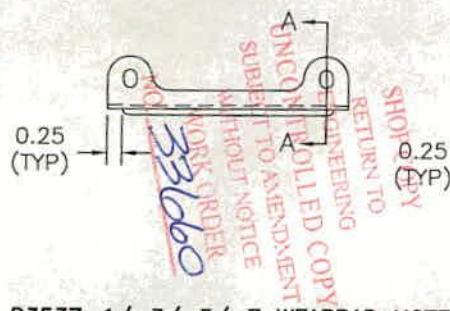
D3537-1F FLAT PATTERN



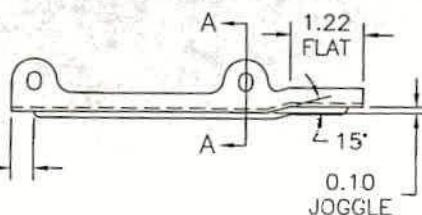
D3537-3F FLAT PATTERN



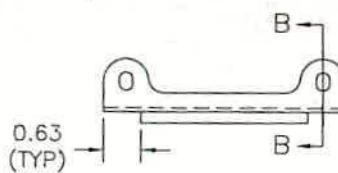
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1E)



D3537-1/-3/-5/-7 WEARPAD NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)

2) BREAK ALL SHARP CORNERS 0.063 MAX

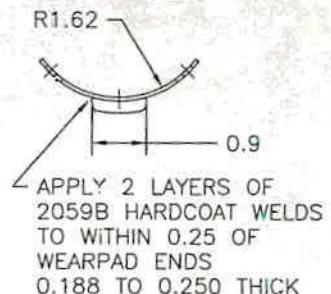
3) WELD PER QSI 004

4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

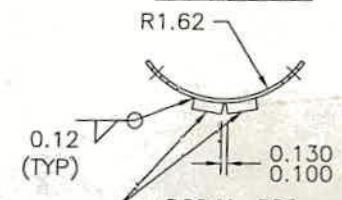
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

SECTION A-A

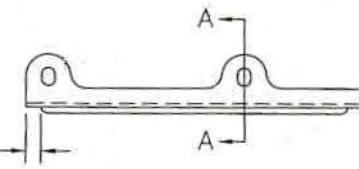


SECTION B-B



THESE
RELEASED
07.05.08 AM

D3537-7 LONGITUDINAL BEN
(MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	
CB	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. C D3537 SHEET 1 OF 1
DATE		TITLE SCALE 07.04.13 WEARPAD 1:2

2025 RELEASE UNDER E.O. 14176

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